

Work Order ID 81408

March-14-12 7:50:11 AM

81408

Page 1

Item ID: D4150-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Attachment Arm Assembly
 Start Date: 13/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4150	B

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								

PICK Kit Sp 12-04-04
 12/04/04 (4)

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

Sp 12/04/04 (4)

120	Identify as per dwg & Stock Location: <u>134</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

12/04/04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81408***81408***

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March-14-12 7:50:11 AM

Item ID: D4150-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Attachment Arm Assembly

Start Date: 13/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

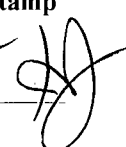
130

QC

Memo

0.00

Quality Control

12/4/5 ME
12-04-04

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Picklist Print

March-14-12 7:50:15 AM

Page 1

Work Order ID: 81408

81408

Parent Item: D4150-041

D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A		Purchased	No			100	Each	61.0000	2	8			
AN3C13A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				61					
				117366				11					
				120630				50					
D4150-1		Manufactured	No			100	Each	1.0000	1				
D4150-1									**				
Arm													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST133				1					
				76301				1					
D4150-3		Manufactured	No			100	Each	4.0000	2				
D4150-3									**				
Arm Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST133				4					
				80739				4					

SP

6x
2x
4

B81214

SP

6
8

B81465

SP 12-04-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-14-12 7:50:15 AM

Page 2

Work Order ID: 81408

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Parent Item: D4150-041

D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

100

Each

840.0000

2

8

MS21043-3

**

SP

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

334

120693

334

ST301

434

118077

2

118614

382

118686

30

119758

20

Ex

NAS1149C0332R

Purchased

No

100

Each

3,725.000

4

16

NAS1149C0332R

**

m1212SS

Washer

SP 12-04-04

Location

Loc Qty

Loc Code

ST297

3725

118354

551

119736

196

120648

2978

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

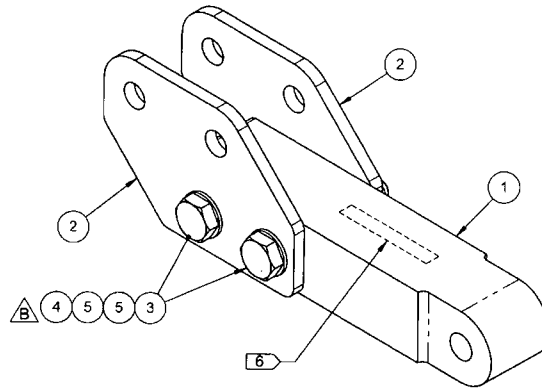
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER



D4150-041 ATTACHMENT ARM ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81408 MCL
12/03/14

RELEASED
2010-07-16

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.82 lbs

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZIN D3-1), Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZIN C6-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4150** REV. B
SHEET 1 OF 3
TITLE **ATTACHMENT ARM ASSY** SCALE NTS

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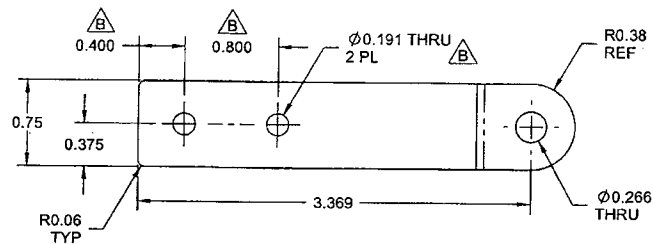
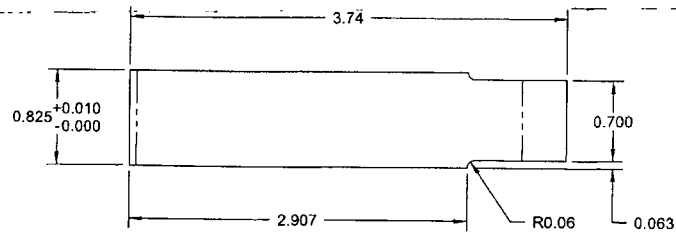
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

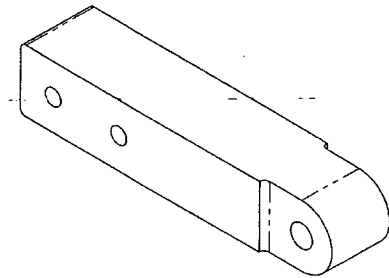
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NOTE: Date & initial all entries



D4150-1 ARM



81408

RELEASED
 2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
 REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

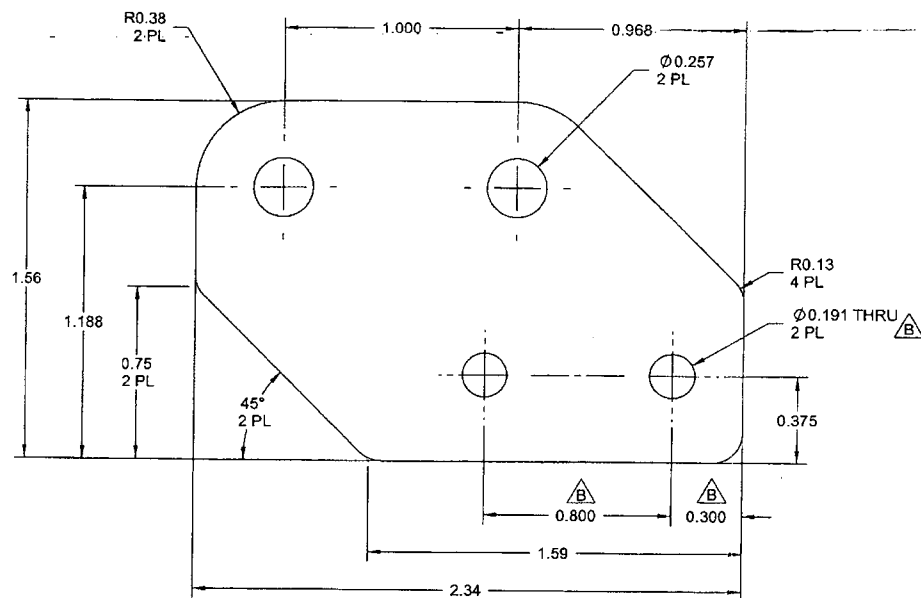
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NOTE: Date & initial all entries



D4150-3 ARM PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4150	SHEET 3 OF 3
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RELEASED
2010-07-16

81408

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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